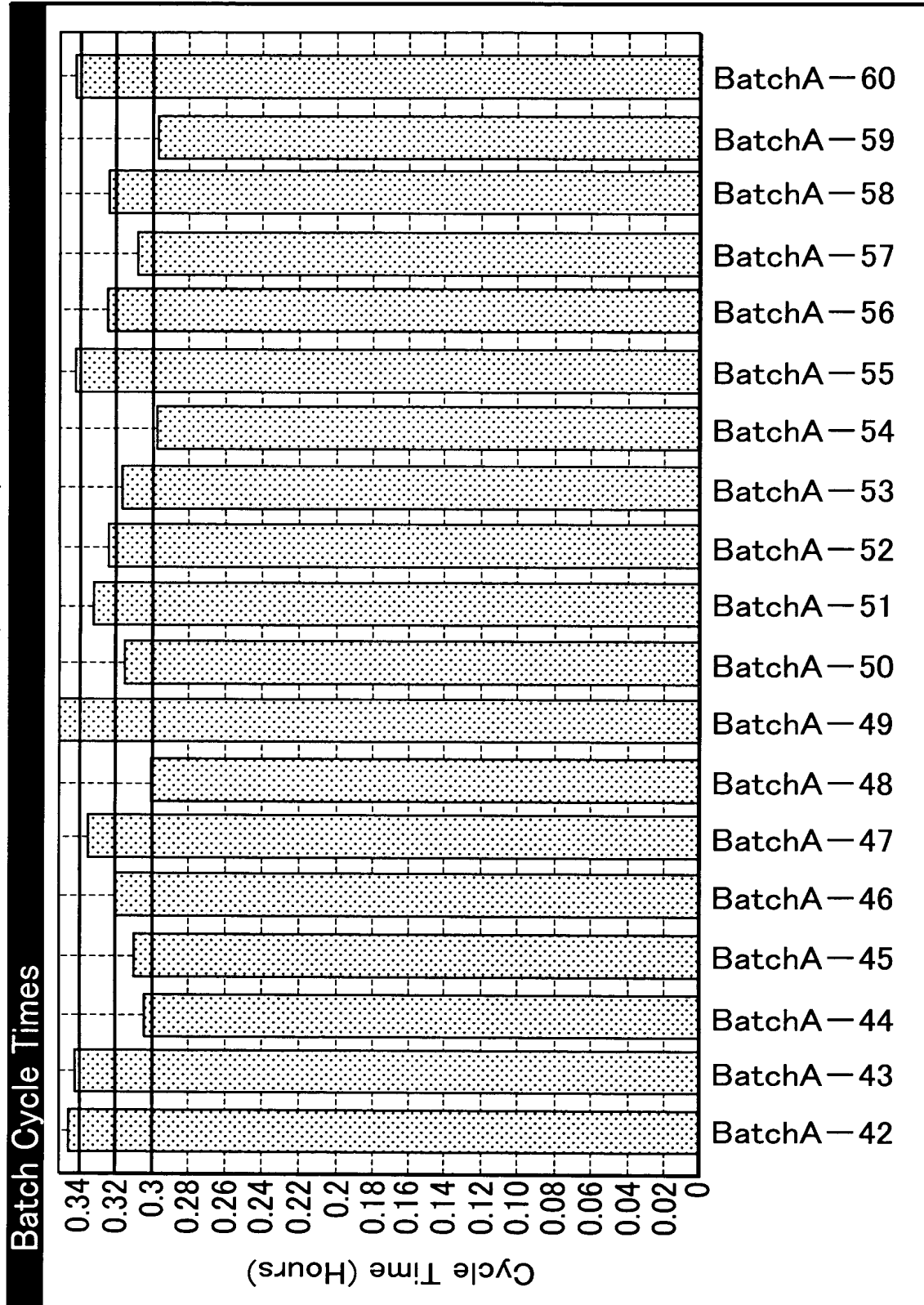
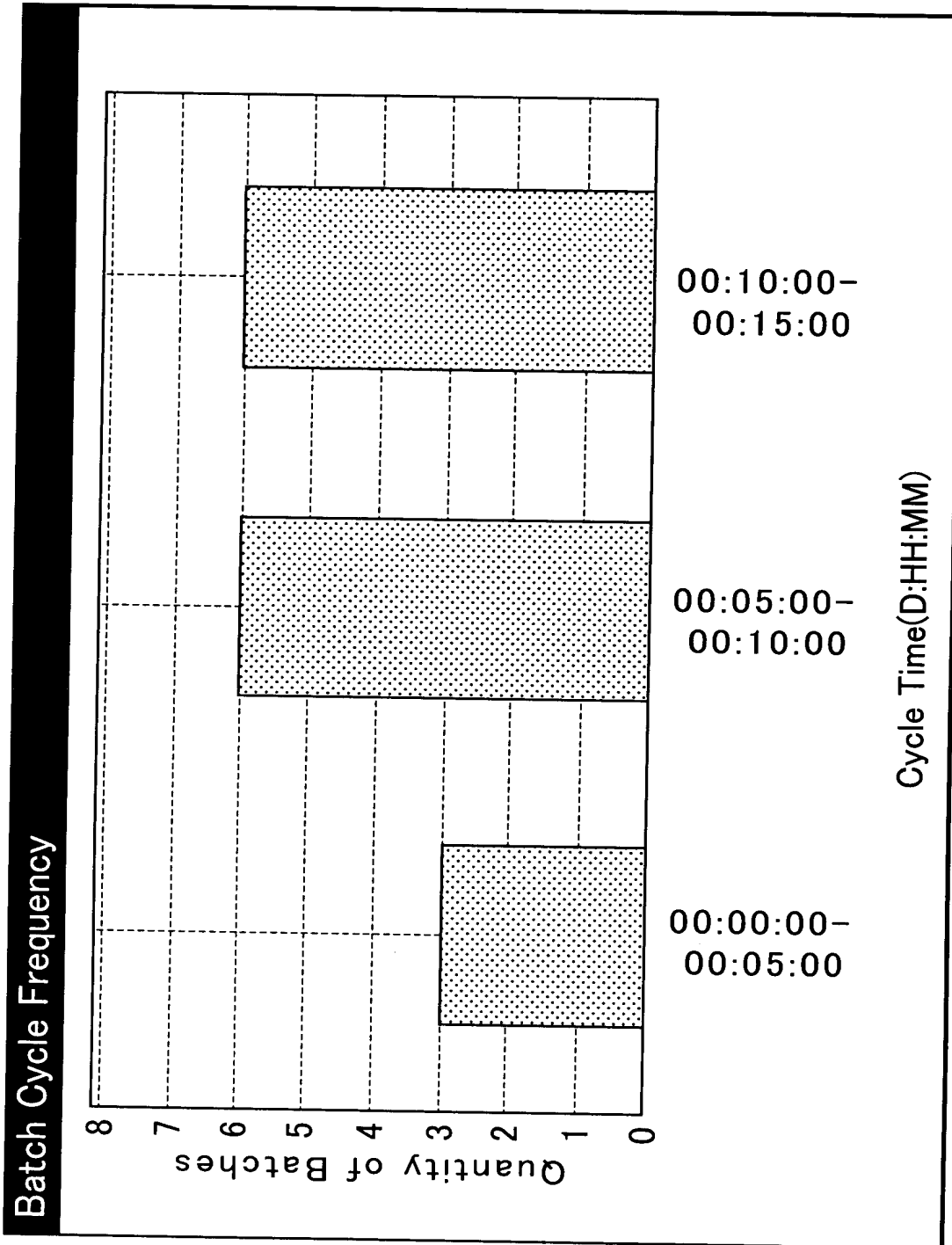


FIG.1 (Prior Art)



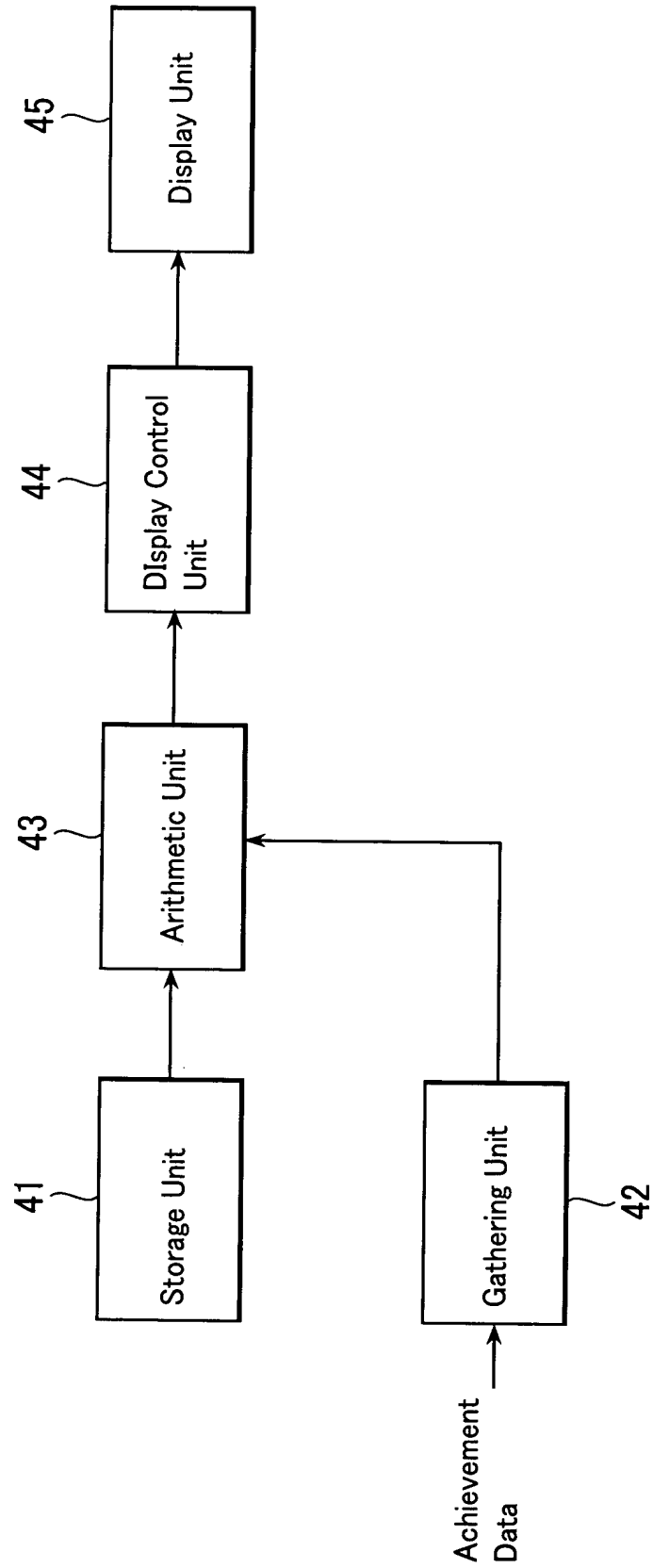
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FIG.2 (Prior Art)



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FIG.3



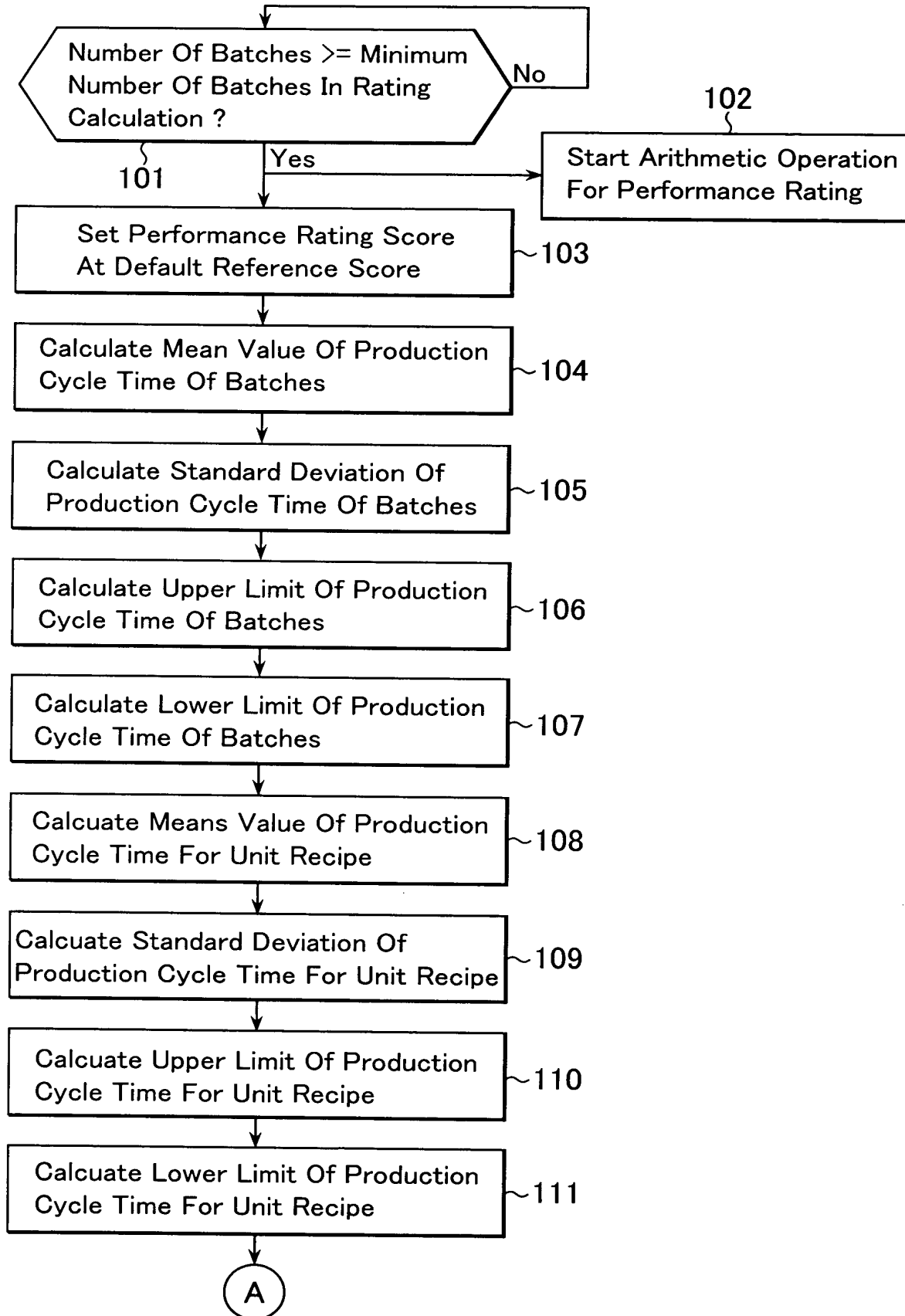
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FIG.4

| Performance Rating Items | Rating Values (Default Values) |
|--|--------------------------------|
| Performance Rating (Default Reference score) | 70 |
| Subtraction Due To Abort | 25 |
| Minimum Number Of Batches In Rating Calculation (Same recipe) | 5 |
| Subtraction In Case Batch Production Cycle Time Exceeds Standard Upper Deviation Limit | 20 |
| Subtraction In Case Batch Unit Recipe Production Cycle Time Exceeds Upper Standard Deviation Limit | 10 |
| Addition In Case Batch Production Cycle Time Is Within Mean Value And Upper Standard Deviation Limit | 10 |
| Addition In Case Batch Production Cycle Time Is Within Mean Value And Lower Standard Deviation Limit | 15 |
| Subtraction In Case Batch Production Cycle Time Exceeds Lower Standard Deviation Limit | 20 |
| Subtraction In Occurrence Of Hold | 10 |
| Time In Hold Limit (%) | 0 |
| Subtraction In Case Time In Hold Limit Is Exceeded | 15 |
| Number Of Alarms Limit | 0 |
| Subtraction In Case Number Of Alarms Limit Is EXceeded | 15 |
| Number Of Alarms Limit Of Unit Recipe | 0 |

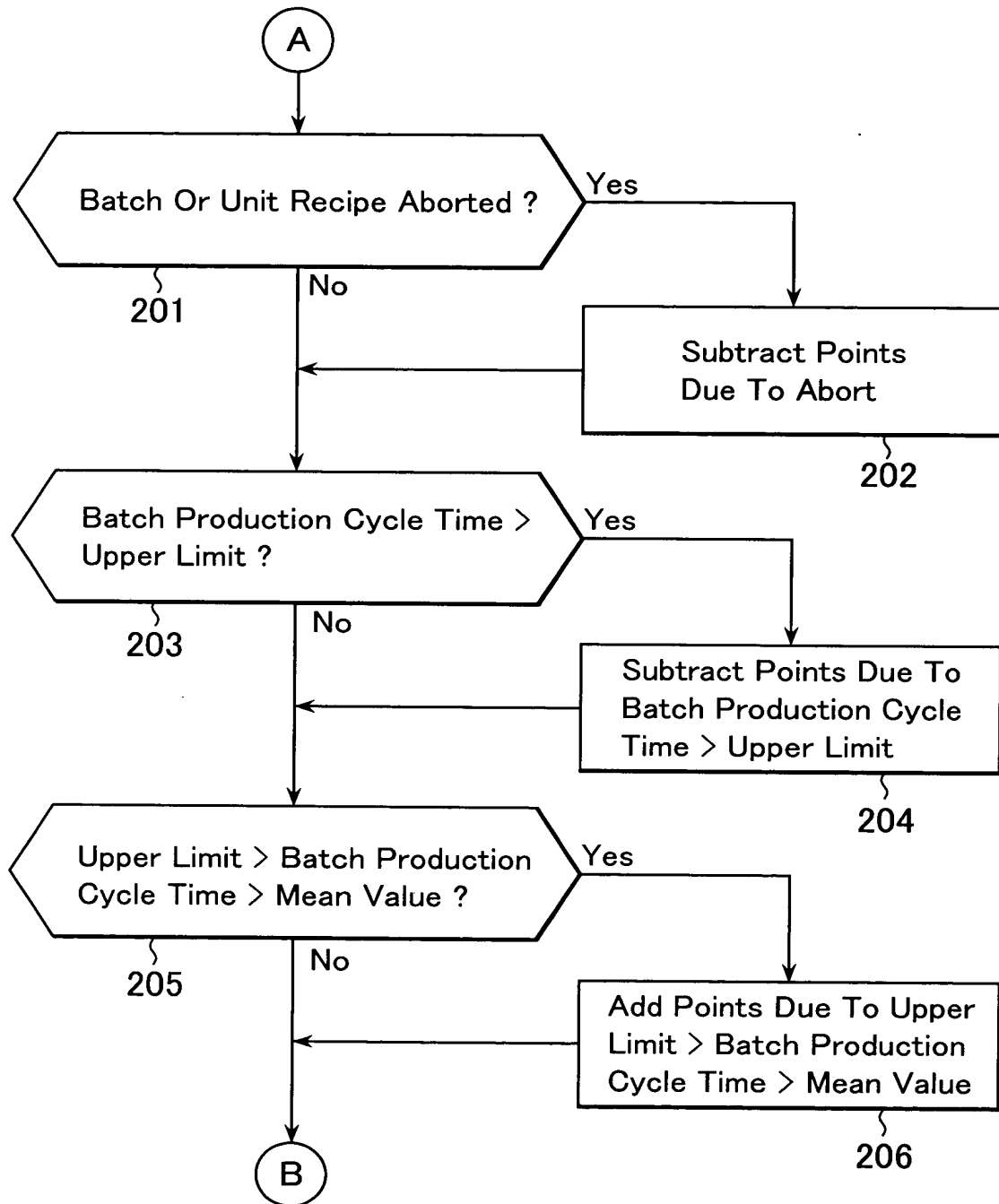
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FIG.5



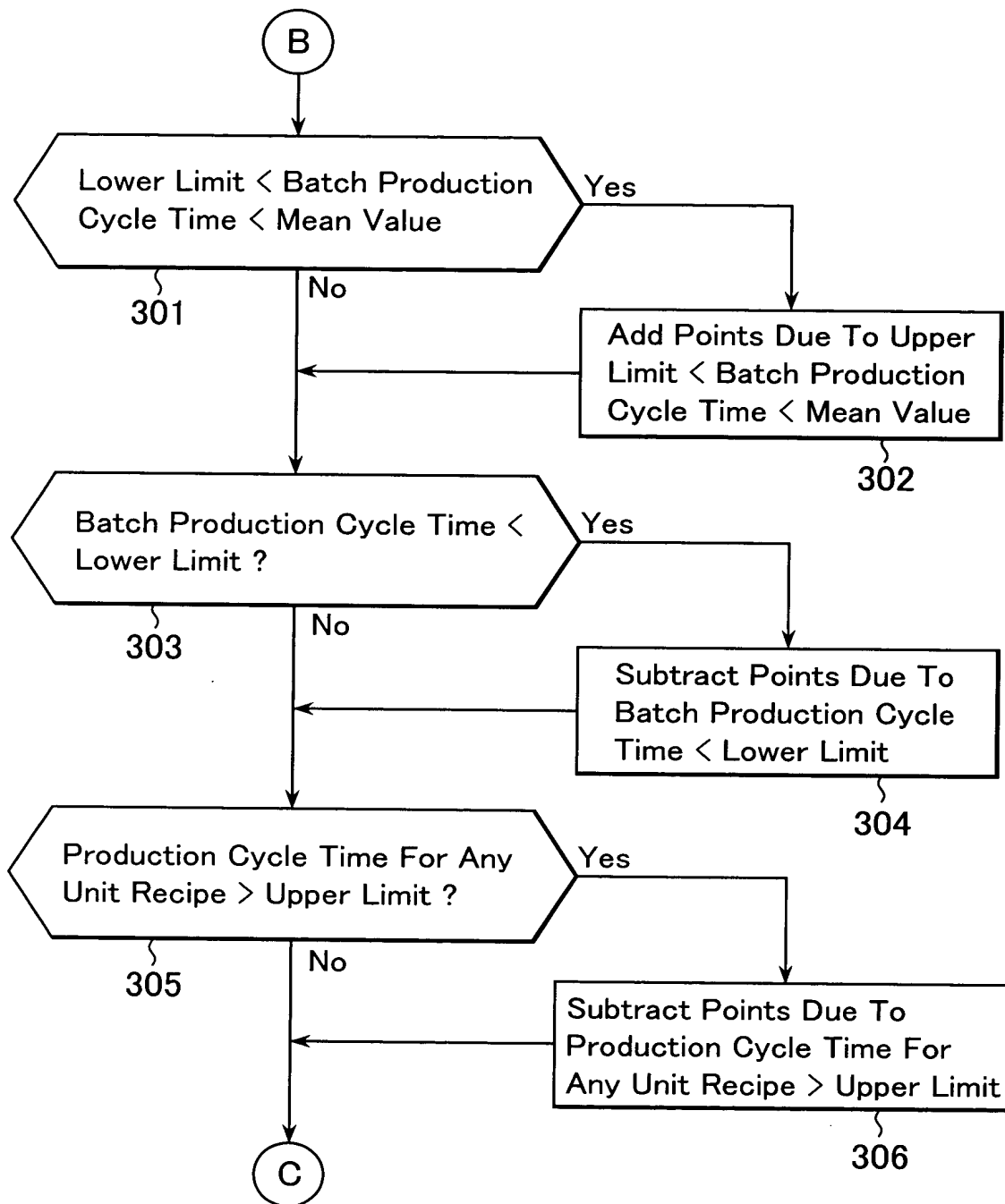
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FIG.6



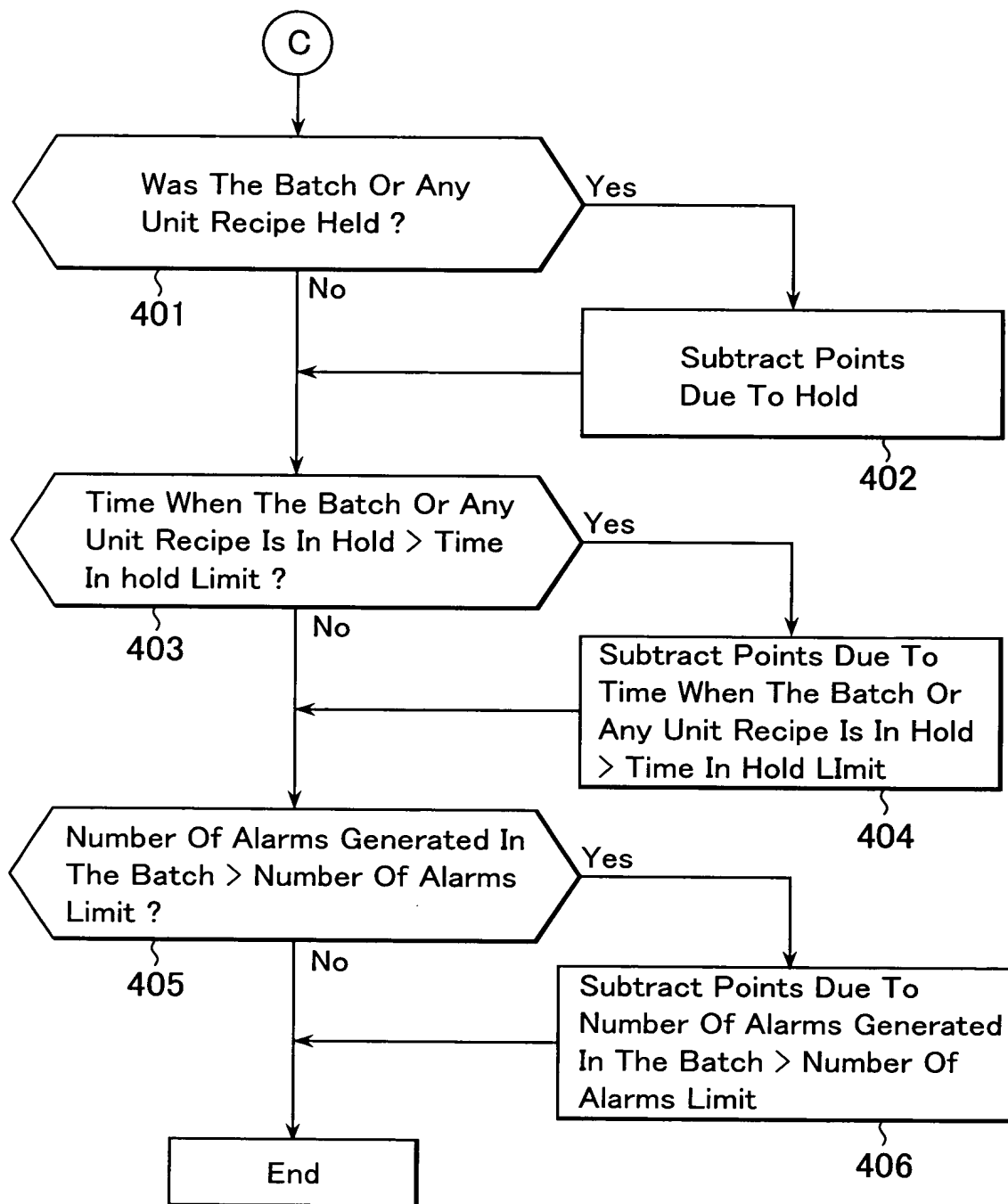
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FIG.7



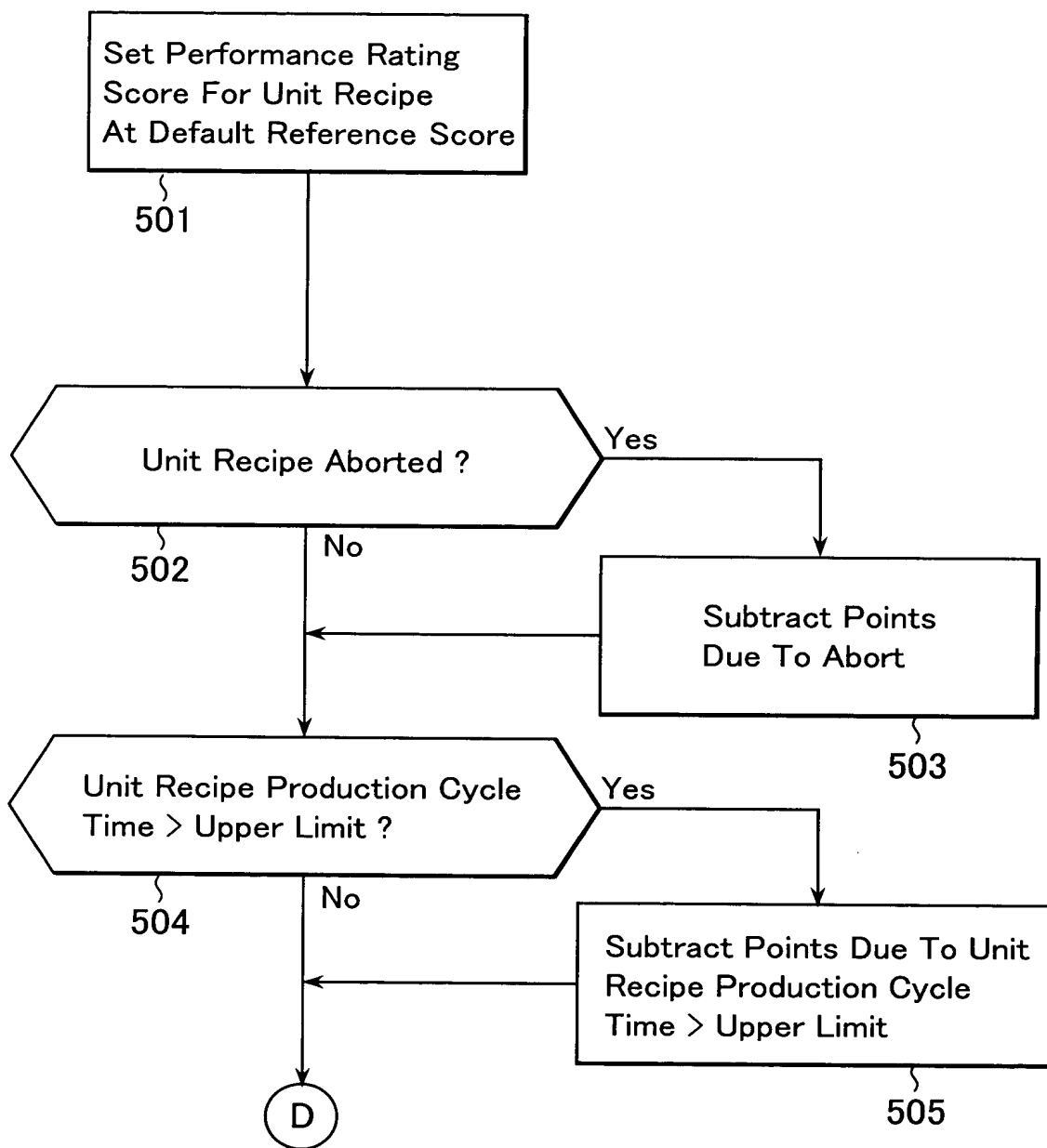
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FIG.8



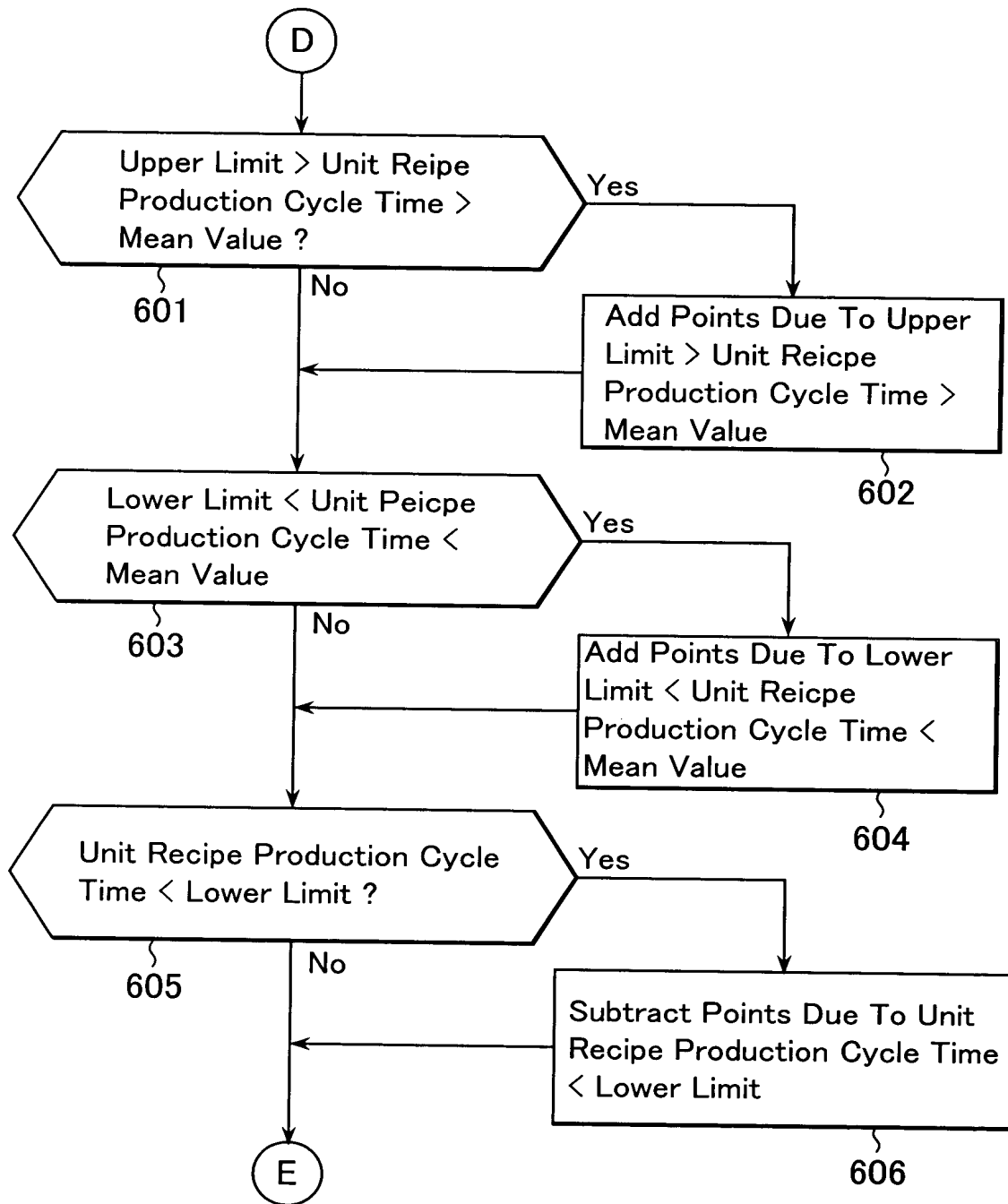
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FIG.9



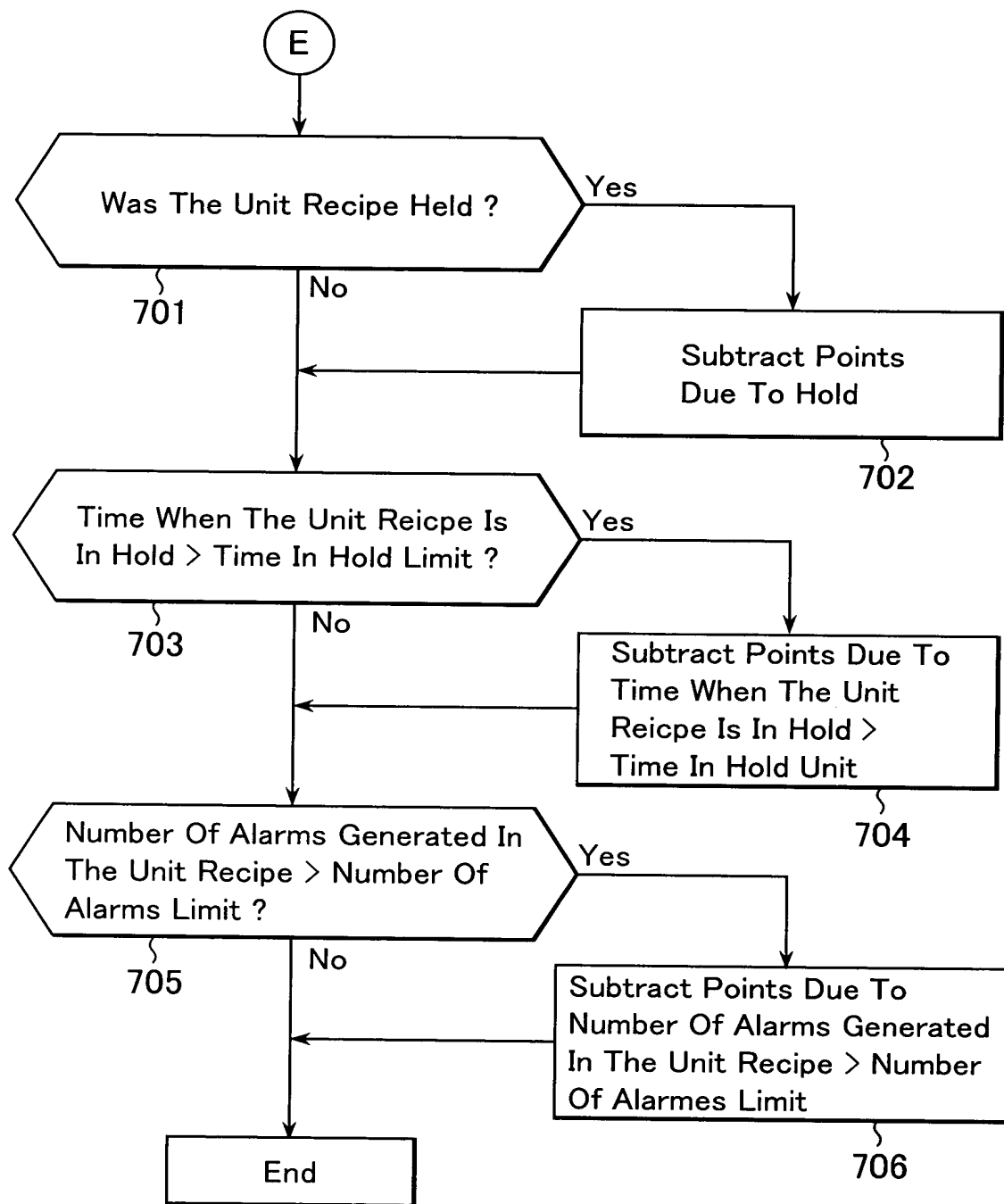
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FIG.10



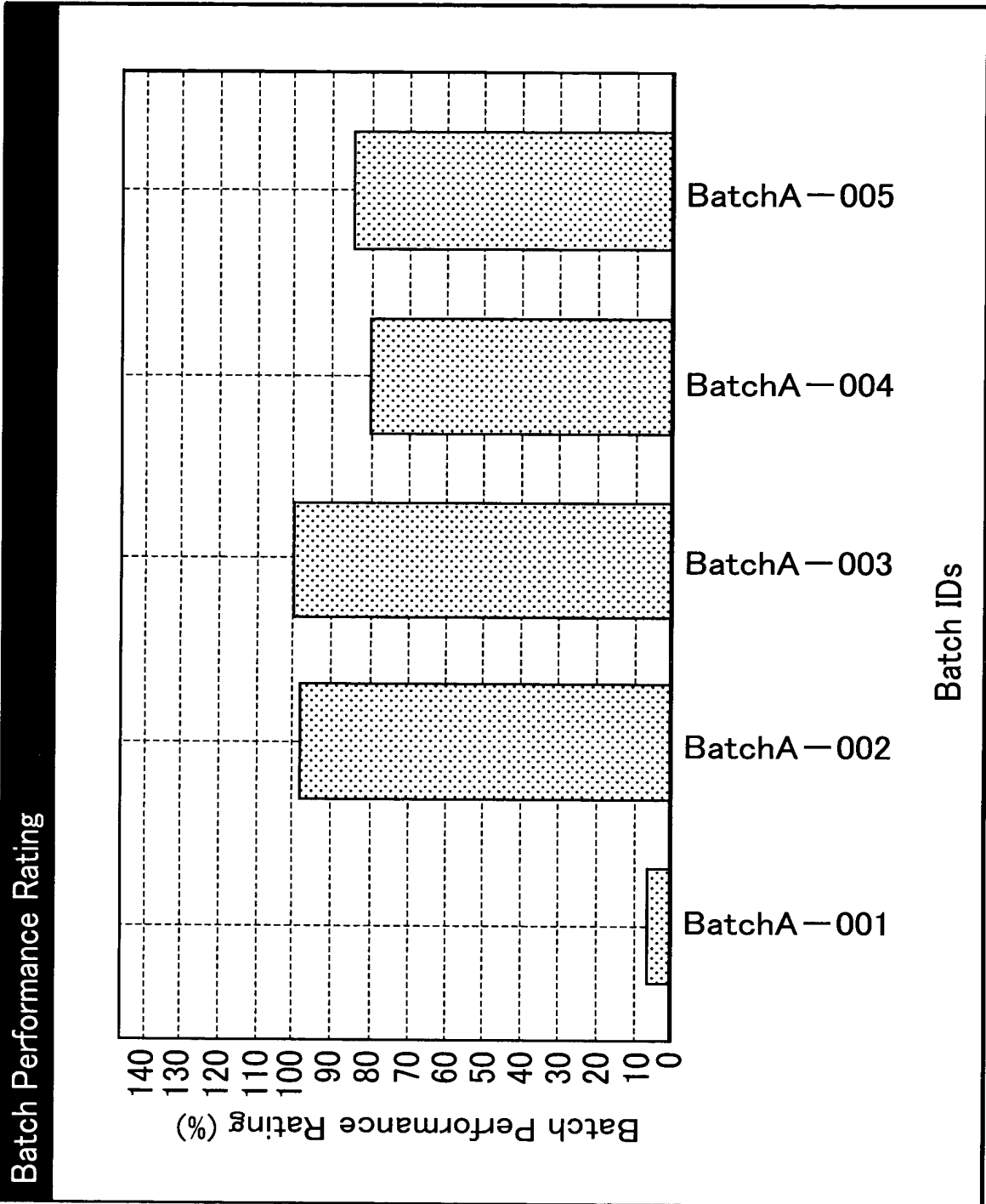
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FIG.11



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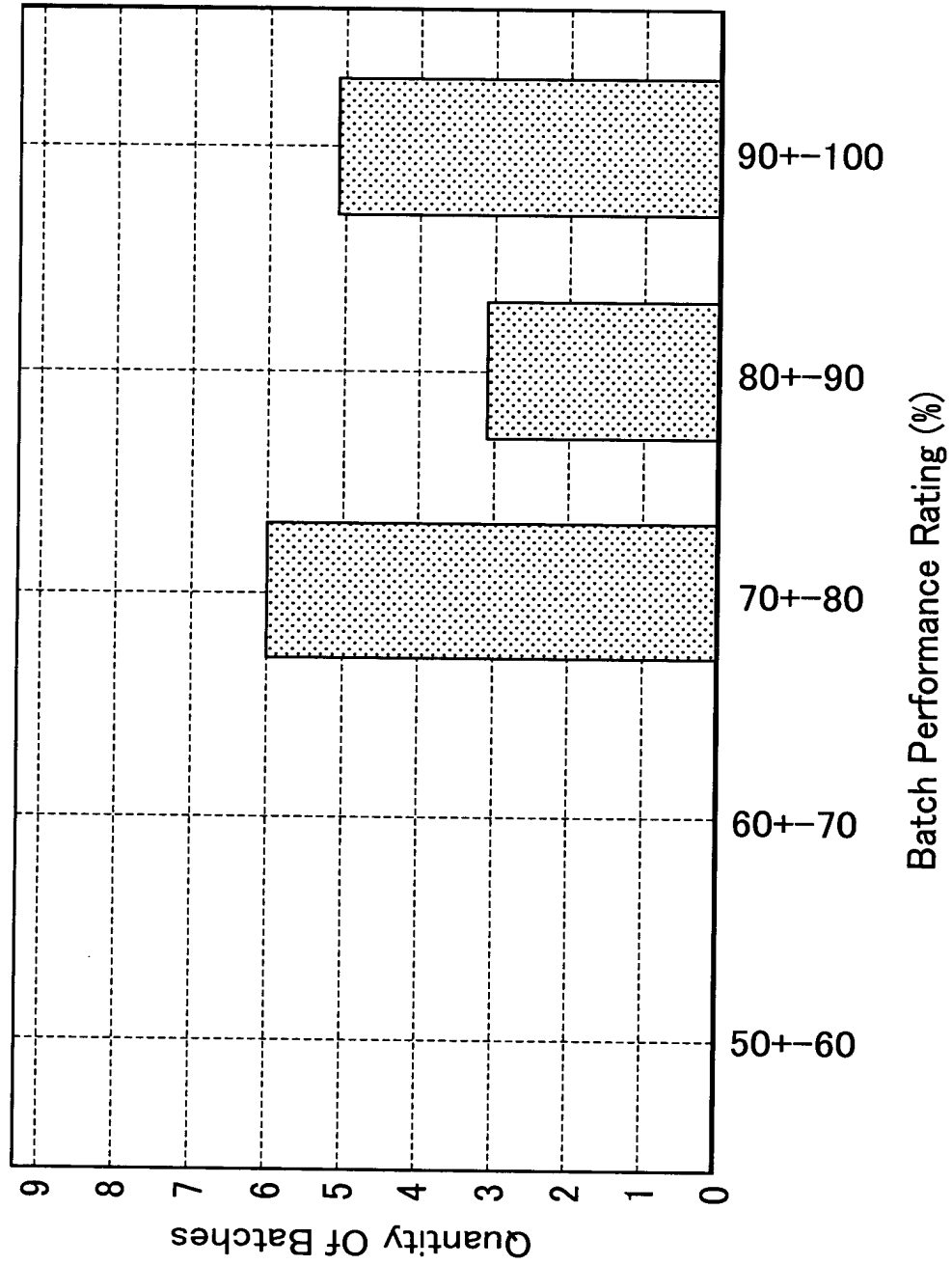
FIG.12



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FIG.13

Batch Performance Rating Frequency



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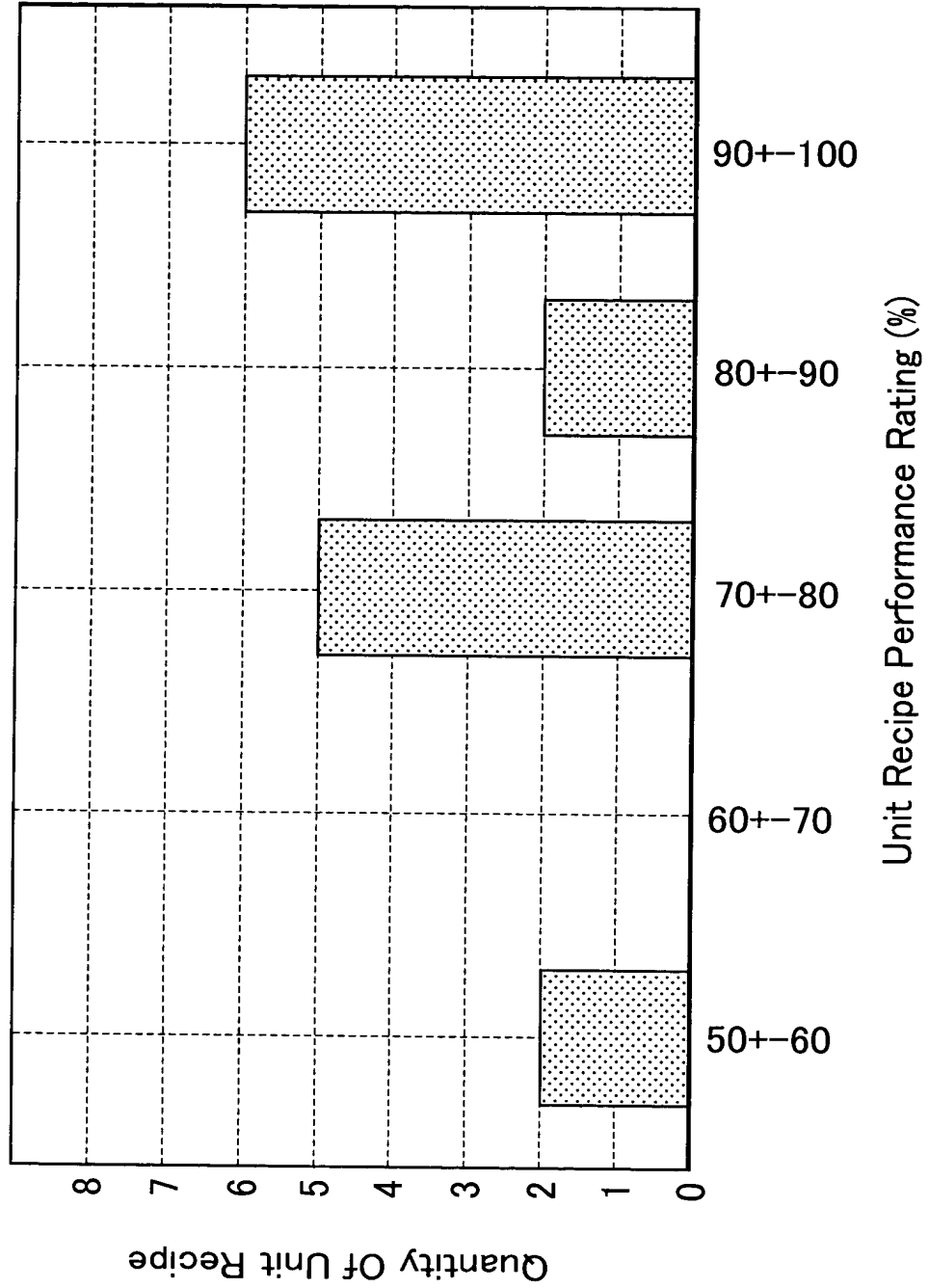
FIG.14



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FIG.15

Unit Recipe Performance Rating Frequency



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FIG.16

